

Sup Feb 13

Date: Tuesday, 2/5/2008 11:07:09 AM  
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABIN FLOOR PROTECTOR
Job Number	: 37205		
Estimate Number	: 12660		
P.O. Number	:	Part Number	: D35741
This Issue	: 2/5/2008 S.O. No. :	Drawing Number	: D3574 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 35240	Material	:
Written By	:	Due Date	: 2/14/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>08 02 05</u>		
Comment	: Est Rev. A New Issue 07-01-22 EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 ~~F60029~~ MLXSI25F6002904 lexan grey



Comment: Qty.: 32.0000 sf(s)/Unit Total : 160.0000 sf(s)

F60029 lexan sheet

Batch: 105330 LB 8-2-7

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: A

Prog Rev: A

LB 8-2-7

(5)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



LB 8-2-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/02/08 (x5)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 08:02:08

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 08/02/12

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/5/2008 11:07:09 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 37205

Part Number: D35741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/12 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 37204 SP (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/12 (5)

Job Completion



h 08.02.12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

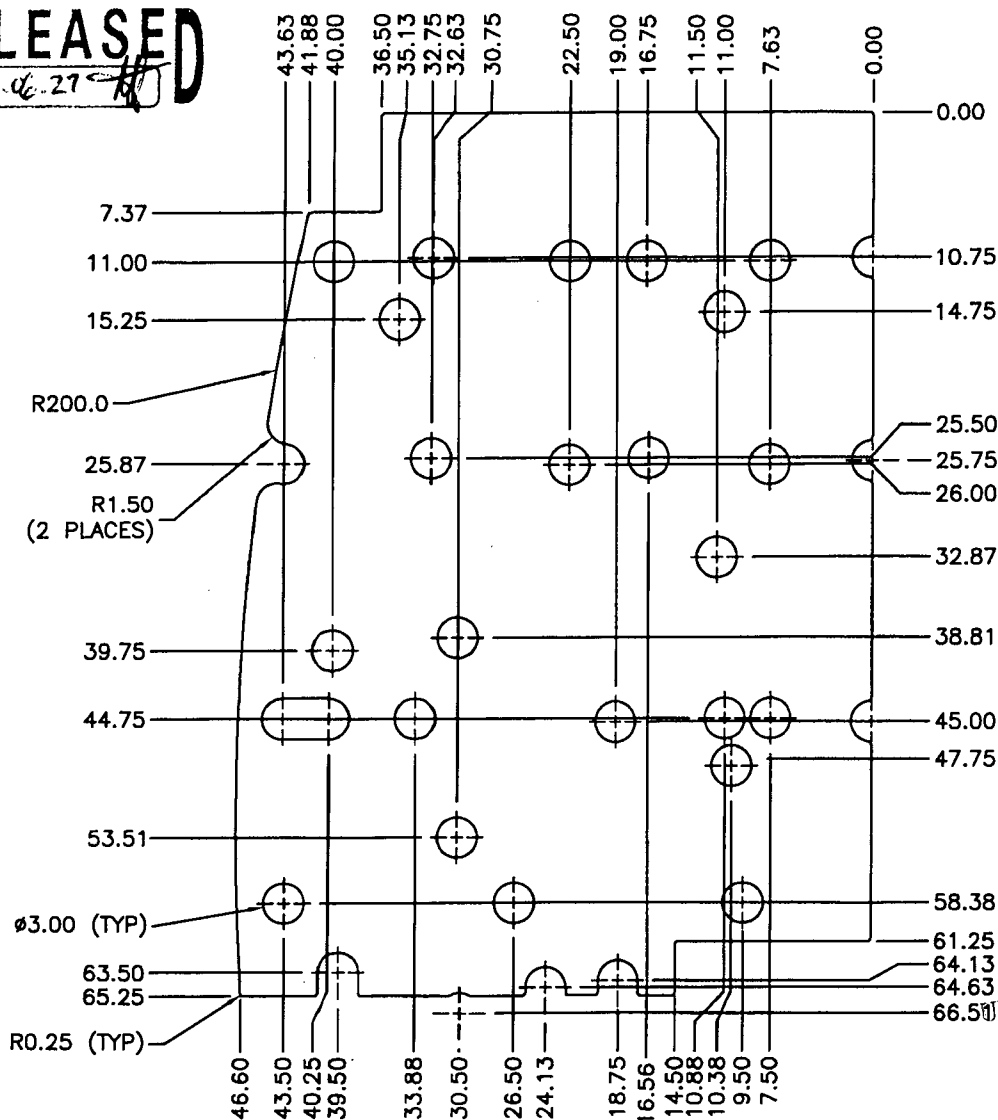
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <b>LE</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>H</b>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

**RELEASED**  
07-06-27

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**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

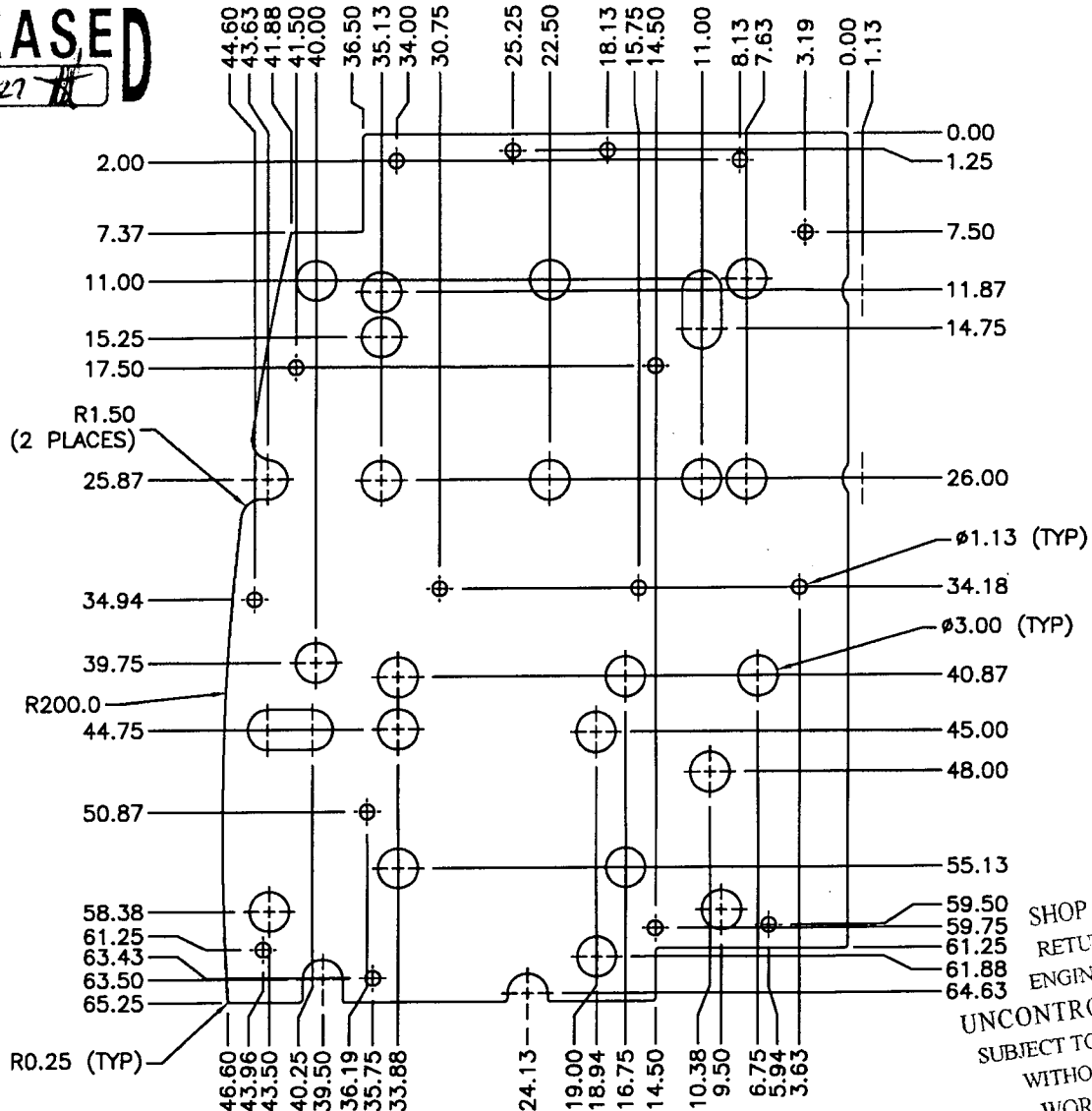
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

**RELEASED**  
07.06.27**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

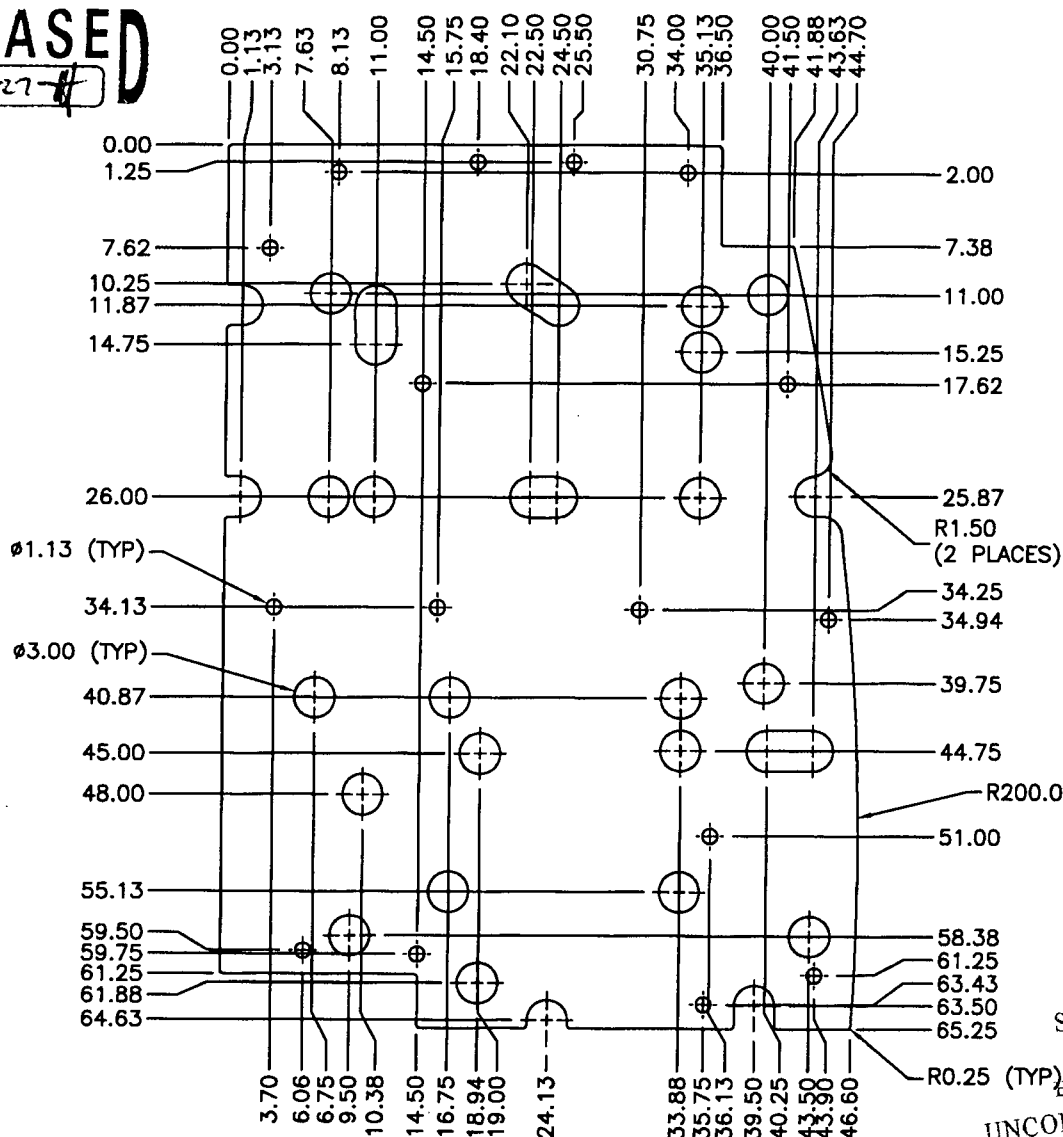
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27-#**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

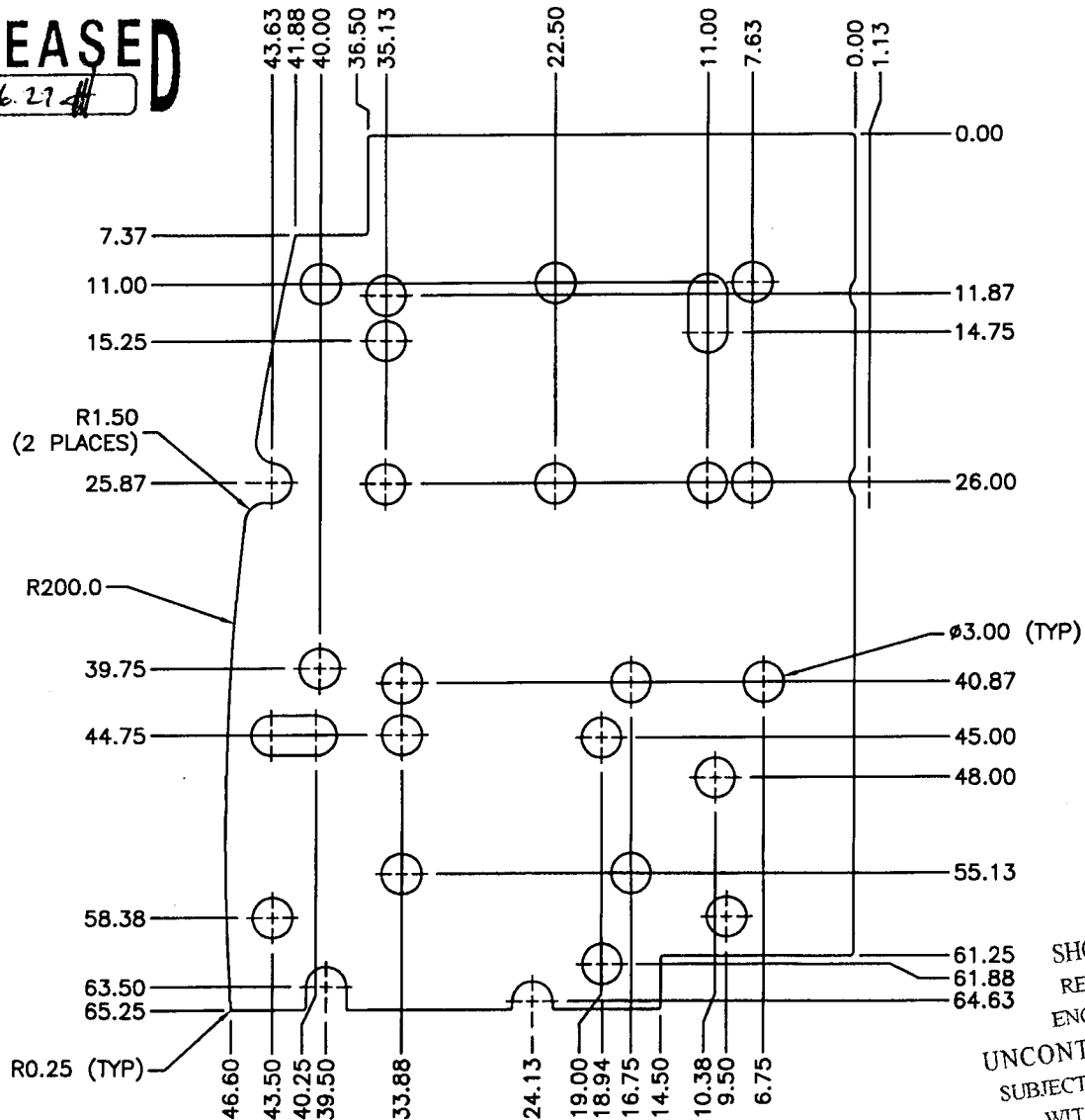
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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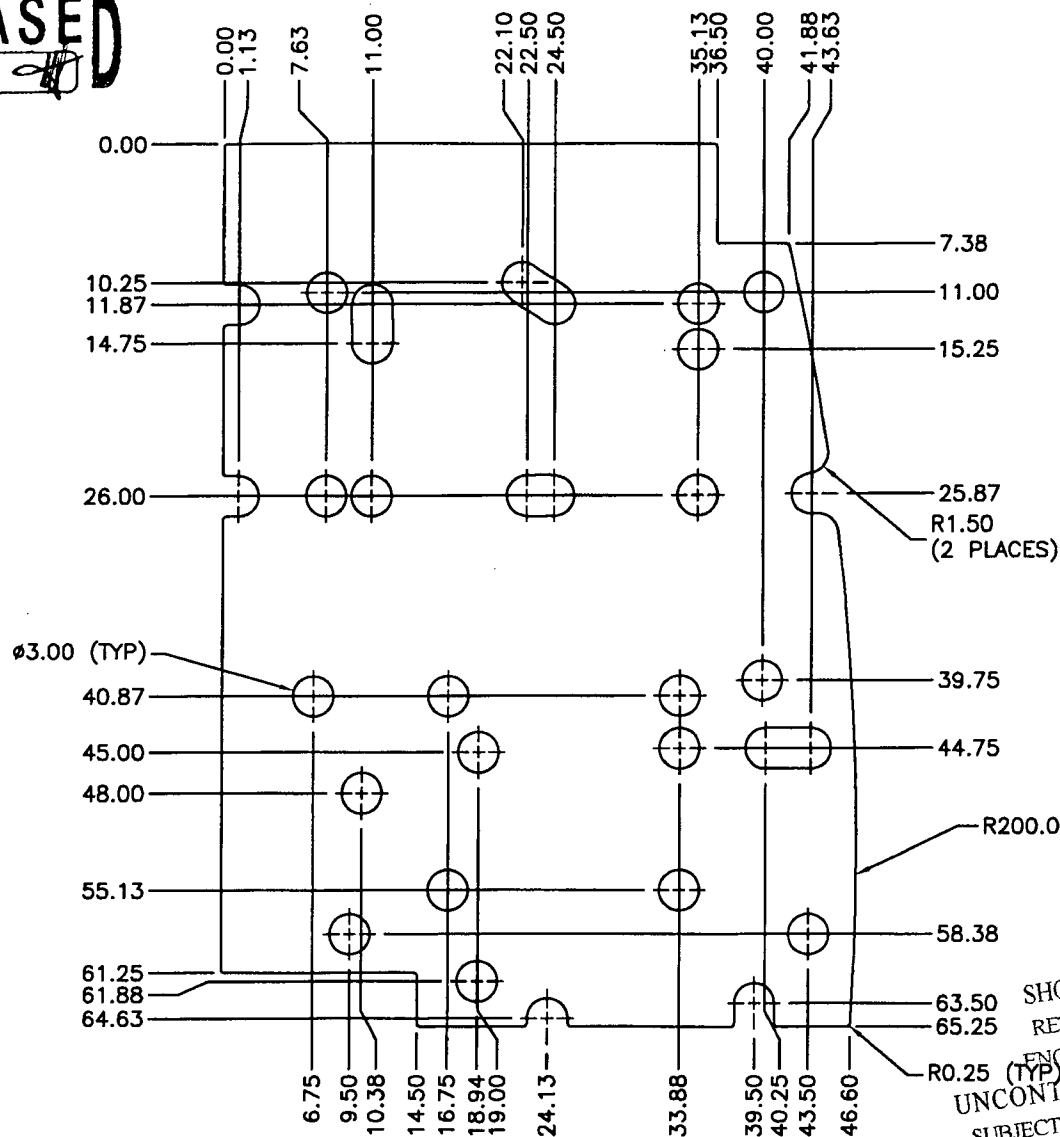
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

**RELEASED**  
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD		Work Order:	37205
Description: CABIN floor PROTECTOR		Part Number:	D3574-1
Inspection Dwg: D3574-1 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	±.030	3.002	X			
7.37	±.030	7.37	X			
11.00	±.030	11.00	X			
15.25	±.030	15.25	X			
25.87	±.030	25.87	X			
39.75	±.030	39.75	X			
44.75	±.030	44.75	X			
53.51	±.030	53.51	X			
63.50	±.030	63.50	X			
65.25	±.030	65.25	X			
10.75	±.030	10.75	X			
14.75	±.030	14.75	X			
25.50	±.030	25.50	X			
25.75	±.030	25.75	X			
26.00	±.030	26.00	X			
32.87	±.030	32.87	X			
38.81	±.030	38.81	X			
45.00	±.030	45.00	X			
47.75	±.030	47.75	X			
58.38	±.030	58.38	X			
61.25	±.030	61.25	X			
64.13	±.030	64.13	X			
64.63	±.030	64.63	X			

Measured by: EB	Audited by: S	Prototype Approval: u
Date: 8-2-7	Date: 08/02/07	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 37205
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-1
Inspection Dwg: D3574-1 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.50	+/- .030	7.50	x			
9.50	+/- .030	9.50	x			
10.38	+/- .030	10.38	x			
10.88	+/- .030	10.88	x			
14.50	+/- .030	14.50	x			
16.56	+/- .030	16.56	x			
18.75	+/- .030	18.75	x			
24.13	+/- .030	24.13	x			
26.50	+/- .030	26.50	x			
30.50	+/- .030	30.50	x			
33.88	+/- .030	33.88	x			
39.50	+/- .030	39.50	x			
40.25	+/- .030	40.25	x			
43.50	+/- .030	43.50	x			
46.60	+/- .030	46.60	x			
7.63	+/- .030	7.63	x			
11.00	+/- .030	11.00	x			
11.50	+/- .030	11.50	x			
16.75	+/- .030	16.75	x			
19.00	+/- .030	19.00	x			
22.50	+/- .030	22.50	x			
30.75	+/- .030	30.75	x			
32.63	+/- .030	32.63	x			

Measured by:	LB
Date:	8-2-7

Audited by:	[Signature]
Date:	8/2/07

Prototype Approval:	[Signature]
Date:	7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

